

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014901**Date Inspected:** 03-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 1

This QA observed ZPMC qualified welding personnel identified as 215397 perform Flux Cored Arc Weld (FCAW) Process repair welding on weld joint 20TR2-028-009. ZPMC Quality Control Personnel (QC) identified as Mr. Xiang Feng Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair-1 and Weld Repair Report B-WR13387.

This QA observed ZPMC qualified welding personnel identified as 203710 perform Flux Cored Arc Weld (FCAW) Process repair welding on weld joint 20TR2-025-013. ZPMC Quality Control Personnel (QC) identified as Mr. Xiang Feng Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair-1 and approved Weld Repair Report B-WR13378.

OBG # BAY 2

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA observed ZPMC qualified welding personnel identified as 045240 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3201-001-052,053. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu Lin was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

During random in- process visual inspection of Traveler Rail, this QA inspector observed that ZPMC personnel was performing buttering (Weld build up) for length. Traveler rail is identified as 20TR1-008. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu Lin was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with approved Critical Weld Repair (B-CWR1568).

OBG # BAY 3

This QA observed ZPMC qualified welding personnel identified as 050977 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3102-001-007,008. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 217805 / 206623 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3111-001-031,032. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 206386 / 048038 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3122-001-024,025. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 044824 perform Flux Cored Arc Weld (FCAW) Process on weld joint FB3166-001-037. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

During random in process visual inspection this QA inspector observed that ZPMC Ultrasonic testing (UT) technician identified as Mr. Xue hai rong perform UT of floor beam lift13E on various weld joints.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

As mention above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
